

# Work Order ID 67360

Wednesday, March 16, 2011 12:04:48 PM



Page 1

Item ID: D3770-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 3/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: 11-03-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3770

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3770 2-drill holes thru to finish size as per dwg D3770 Using DT9410, Locate tube on stop labelled #1 and then drill holes labelled #1 3- deburr

*7m-L 11/03/16*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*5w/03/17*

*(+10)*

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*10 BR 11-3-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67360**

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Item ID: D3770-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 3/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10  $\phi$  11/03/21

140

Identify as per dwg &amp; Stock Location: 250

0.00



Packaging

Memo

0.00

Packaging

11/13/22 (1-)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/13/22

MF 11-03-22

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 16, 2011 12:04:54 PM

Page 1

Work Order ID: 67360



Parent Item: D3770-1



Parent Item Name: Tube

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC  
IPP Rev:B Added Drilling Tooling 08-08-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T1.000W065

Purchased

No

100

f

50.5728

1.1358

11.95579



*M.J. 11/03/16*

6061T6 RD TUBE 1.00 x .065w

Location

Loc Qty

Loc Code

MAT015

50.57283748

113511

13.7388405

114089

9.228737

116720 ✓

27.60526

*11-95579*

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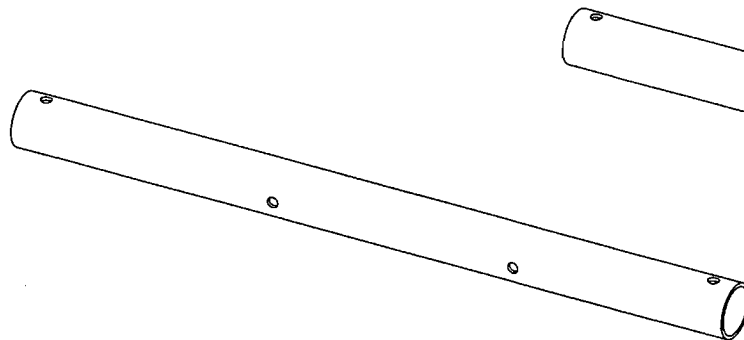
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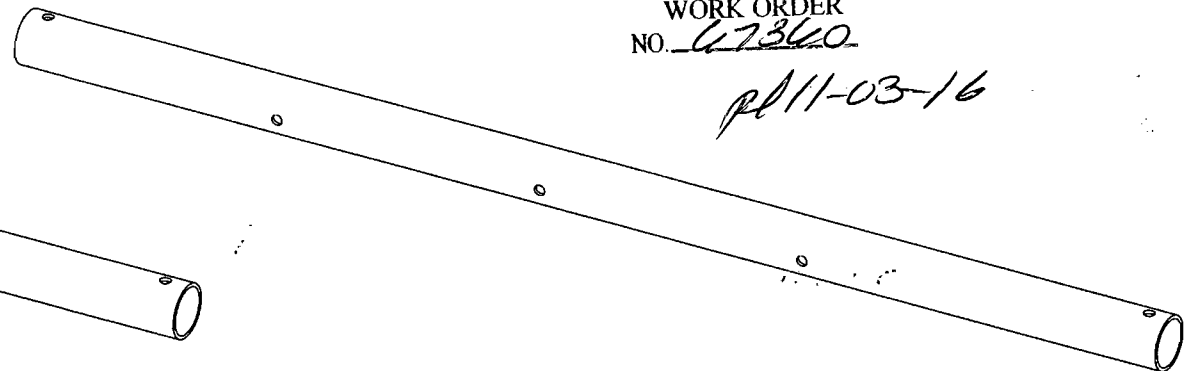
**NOTE:** Date & initial all entries

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67360

*pl11-03-16*



**D3770-1 TUBE**



**D3770-3 TUBE**

*RELEASED*  
*08-07-10*

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3770</b>	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>TUBE</b>	NTS
DATE	08.06.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

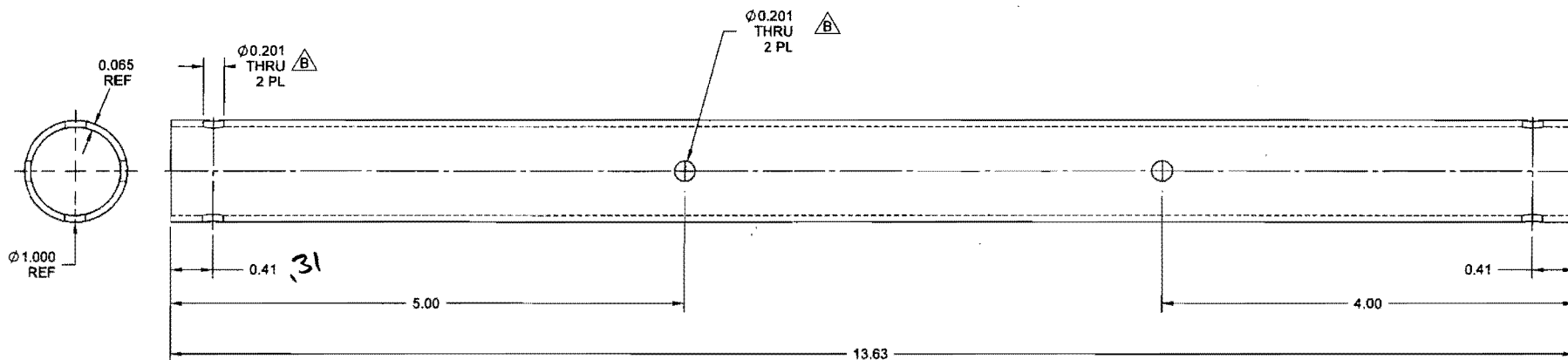
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**NOTE:** Date & initial all entries



W/O 67360



**D3770-1 TUBE**

RELEASED  
0807101740

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		TITLE <b>TUBE</b>	SHEET 2 OF 3
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DE APPR.			NTS
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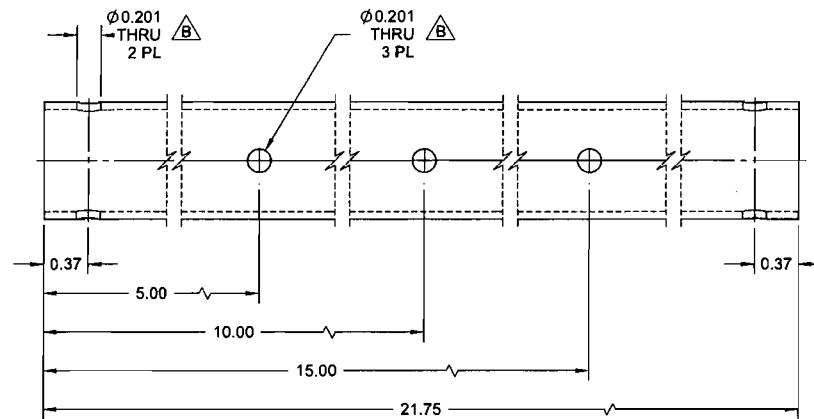
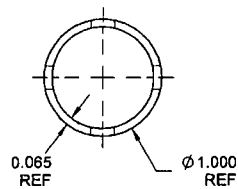
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w/o 67360



**D3770-3 TUBE**

RELEASED  
11/05/07 10/11

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CHECKED	HS	DRAWING NO.	REV. B
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APPROVED	HS	TITLE	SCALE
DE APPR.	HS	TUBE	NTS
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